



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4766-041-BENT
Job Sheet 199933



Part No: D4766-041-BENT

Job Qty: 1 pcs

Part Name: Extrusion Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP REV:A 16.05.16 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs	9/18/19	9/18/19	0.00	1.49	Skidtubes - Bend	MAG TF	
120	QC 5	1 pcs	9/18/19	9/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/18/19	9/18/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S213521



Part: D4766 - 041 - BENT

Job No: 199933

Serial No/Batch: S213521

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 09/13/19

Plex 9/5/19 7:36 AM Dart.lajeunesse.marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BC
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	9/18/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 110 - Skidtubes - 1- Bend FWD end as per dwg and folio 2- Cut FWD end as per dwg using DT8185 ***VERIFY
 Descriptions: MESUREMENT****
 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: LG002
 140 - QC21- Final Inspection - Work Order Release

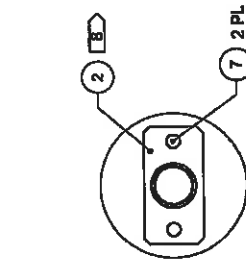
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2962-190	Extrusion	1 pcs (1 ea)	110-Skidtubes - Bend - 1	5155/45

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2962-190	1	42	0

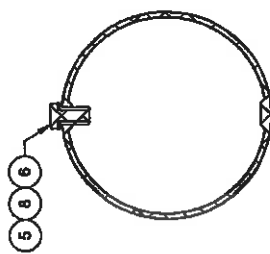
Part Specifications	
Specifications could not be found.	

Plex 9/5/19 7:36 AM Dart.lajeunesse.marie

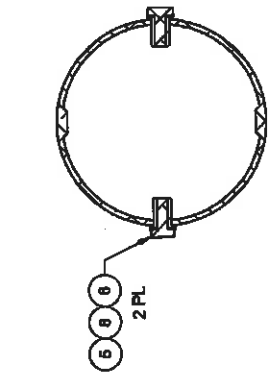
ITEM	QTY	PIN	DESCRIPTION
	043		SKIDTUBE SUB ASSY
1	11	D4766-043	SPACER
2	22	D4763-1	DOUBLER
3	1	D4766-045	SKIDTUBE SUB ASSY
4	2	D5304-1	CROSSBOLT SPACER
5	3	AE18-1032-180	INSERT
6	3	AN324A	BOLT
7	44	MS20801AD4W3	RIVET, BLIND, GSK
8	3	NAS1149C032R	WASHER



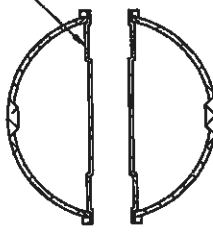
DETAILS
SCALE 8X
22 PL



SECTION D-D
SCALE 6X



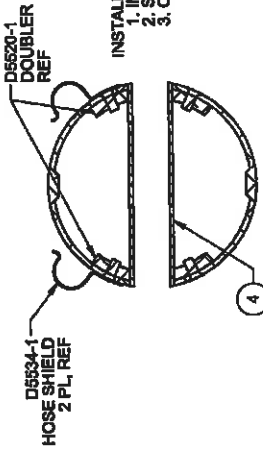
SECTION F-F
SCALE 6X



SECTION C-C
SCALE 6X
11 PL

INSTALL D4688-1 SPACER AFTER INSTALLING D4763-1 DOUBLERS AS FOLLOWS (11 PL)

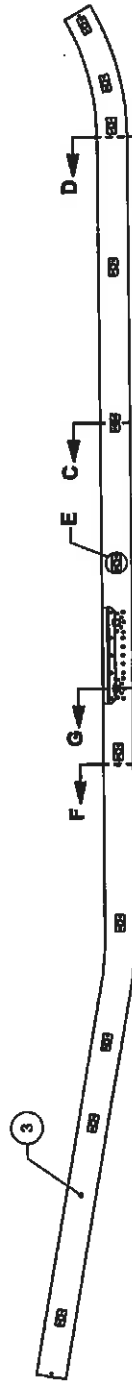
1. INSERT D4688-1 SPACER
2. SWAGE TO Ø0.980 +0.005/-0.000 X 1.0 DEEP PER OSI 002
3. TRIMGIND FLUSH PER OSI 002



SECTION G-G
SCALE 6X
2 PL

INSTALL D5304-1 SPACER AS FOLLOWS (2 PL)

1. INSERT D5304-1 SPACER
2. SWAGE TO Ø0.980 +0.005/-0.000 X 1.0 DP PER OSI 002
3. OPEN THRU HOLE TO Ø0.625



D4766-043 SKIDTUBE SUB ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1 PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART OSI 005 4.2
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 33.8 lbs
 - 8) SEAL FAYING SURFACES USING PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT

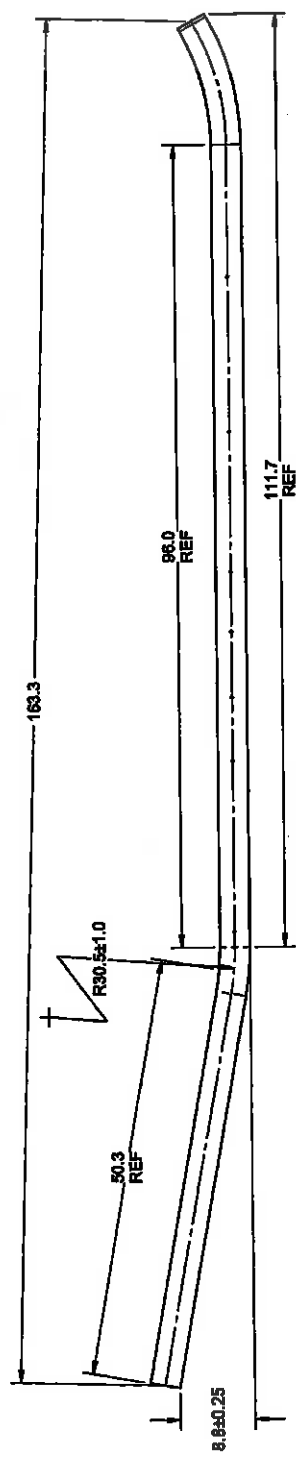
APPROVED

RELEASED
2017-08-11

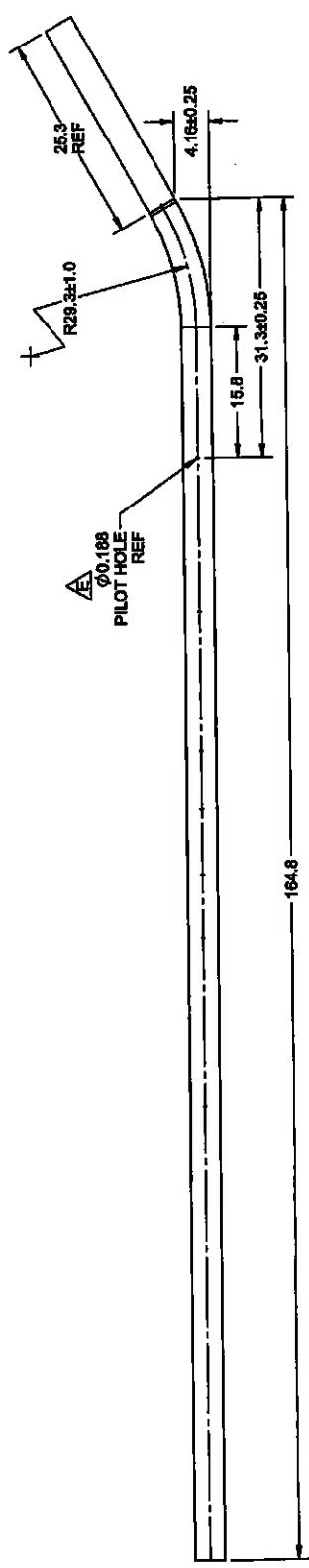
DESIGN	AP	ALIS	DART AEROSPACE USA, INC.
DRAWN	ML	DP	EUGENE, OR
CHECKED	ML	DP	DRAWING NO. D4766
MFG. APPR.	WM	DS	REV. E
APPROVED	WM	DS	SHEET 3 OF 7
DE APPR.	WM	DS	SCALE
DATE	17.03.30	DS	NTS

SKIDTUBE
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1 2 3 4 5 6 7 8



D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, AFT BEND)



D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, FWD BEND)

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. E
MFG. APPR.	DP	D4766	SHEET 5 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
DATE	17.03.30		

RELEASED
R 2017-08-11

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APPROVED

APPROVED

APPROVED

APPROVED

1 2 3 4 5 6 7 8

D

C

B

A

Ø0.287
TOP SIDE ONLY

149.00

Ø0.188
THRU
7 PL

35.38

16.78

180.0

98.11

91.03

83.11

75.66

55.10

D4766-1 SKIDTUBE

- NOTES:
- 1) MATERIAL: MAKE FROM D2092-180 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.01 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART BIN PER QSI 044 METHOD 6.4
 - 7) WEIGHT: 16.97 lbs

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. E
MFG. APPR.	DP	D4766	SHEET 7 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DSC	SKIDTUBE	NTS
DATE	17.03.30	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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RELEASED
2017-08-11
APPROVED

1 2 3 4 5 6 7 8



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: